

9/10/2008 8:08:36 AM

Process Sheet

AR01 Dart Aerospace Ltd.

Drawing Name : PROTO

: 10804

Part Number : D36373

Drawing Number : D3637 PROTO

Prsht Rev. : 28/10/2008 S.O. No. :

Project Number :

First Issue : 27/10/2008

Type : R & D SM/MED FAB

Drawing Revision :

Previous Run : 00015

Material :

Written By : 

Due Date : 03/11/2008

Qty: 1 Um: Each

Checked & Approved By : 

Comment :

Additional Product :

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO LOGGING

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

WATER JET

FLOW WATER JET

A
A

B 8-10-28



Comment: FLOW WATER JET

CUT PER DRWG D3637 REV.B

2.0

M304S14GA

304SS sheet .080



Comment: Qty.: 0.1000 sf(s)/Unit Total: 0.1000 sf(s)
304SS sheet .080

3.0

M2024T3S050

2024-T3 .050 sheet



105646

B 8-10-28



Comment: Qty.: 0.1600 sf(s)/Unit Total: 0.1600 sf(s)
2024-T3 .050 sheet

DEBURF B 8-10-28

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 8-10-28



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8061028 (42)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

BEND PER DRWG D3637 REV. B : drill
NOTE RADIUS CHANGE

803 08/10/04

Date: Tuesday, 28/10/2008 8:08:36 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PROTO

Job Number: 05051

Part Number: D36373

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-04 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
GIVE TO ALAN/DAN S
FOR AIRCRAFT FIT

*Scrap parts per
Alan 08-11-05 W 08-11-05*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06 (J)

Job Completion

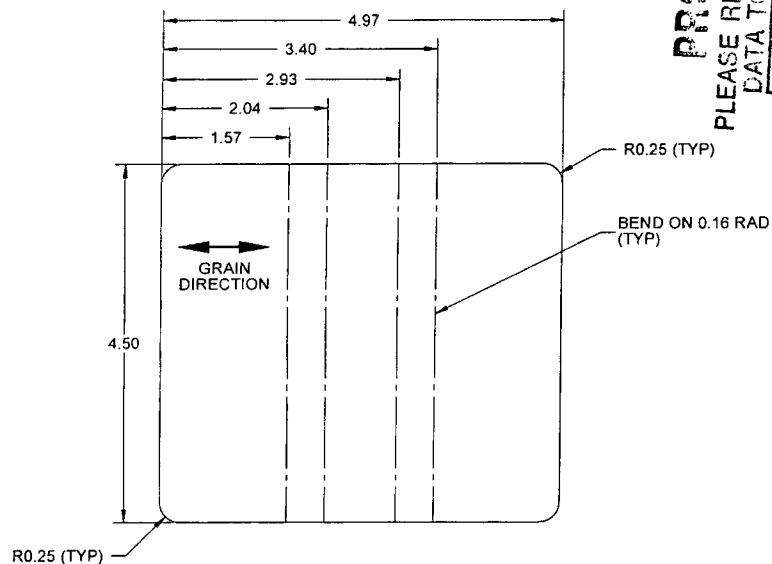


W 08-11-05

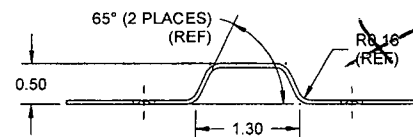
*All parts made on this W/O
were prototypes for Engineering
check fit use only. All parts to
be scrapped after check fit
completed.*

ASS 08 11.05

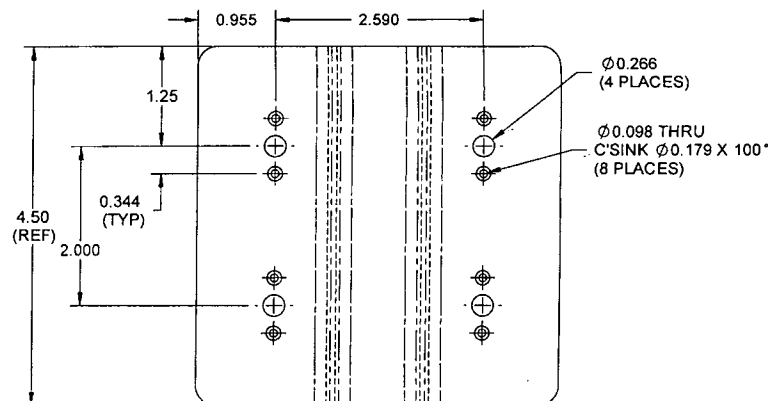
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING



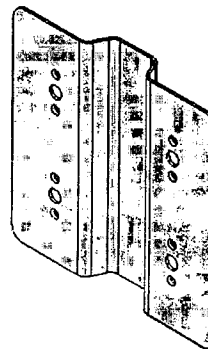
D3637-3F FLAT PATTERN



20.18-20.19
MS
08.10.27



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D3637	SHEET 3 OF 3
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	BRACKET	2:3
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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Date: Monday, 27/10/2008 1:53:48 PM
 User: Linda Lacelle

Process Sheet

FOR ENGINEERING USE ONLY

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : PROTO

Job Number : 05051

Estimate Number : 10804

P.O. Number :

Part Number : D36373

This Issue : 27/10/2008 S.O. No. :

Drawing Number : D3637 PROTO

Prsht Rev. : NC

Project Number :

First Issue : / / Type : R & D SM/MED FAB

Drawing Revision :

Previous Run : 00015

Material :

Due Date : 03/11/2008

Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment :

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

CUT PER DRWG D3637 REV.B

109358

18-10-27

wrong drwg
given by ENG

(3)

2.0

M304S14GA

304SS sheet .080



PROTO

18-10-27



Comment: Qty.: 0.1000 sf(s)/Unit Total: 0.1000 sf(s)
 304SS sheet .080

see used w/o 42994

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18-10-27

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

BEND PER DRWG D3637 REV. B

NOTE RADIUS CHANGE

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

5051

Product #: D350-764

Job #: 00569

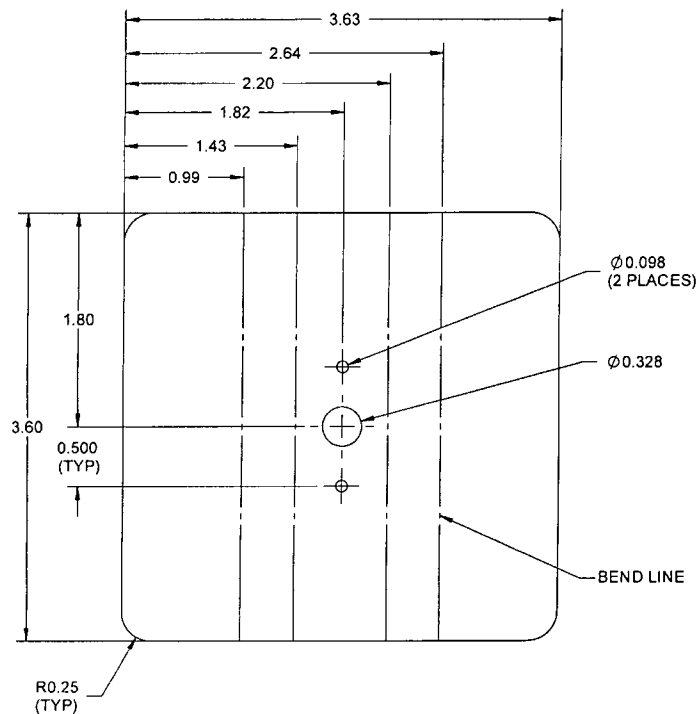
Date: 27-Oct-08

Product Name: Rear Shoulder Harness Kit

Requested By: AJS

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3637-3		Bracket	08.10.27	Y	08.10.28	SEE ATTACHED MARK-UP CHANGE BEND RAD TO	
							R0.18-0.19. CHECK FIT ON AIRCRAFT	

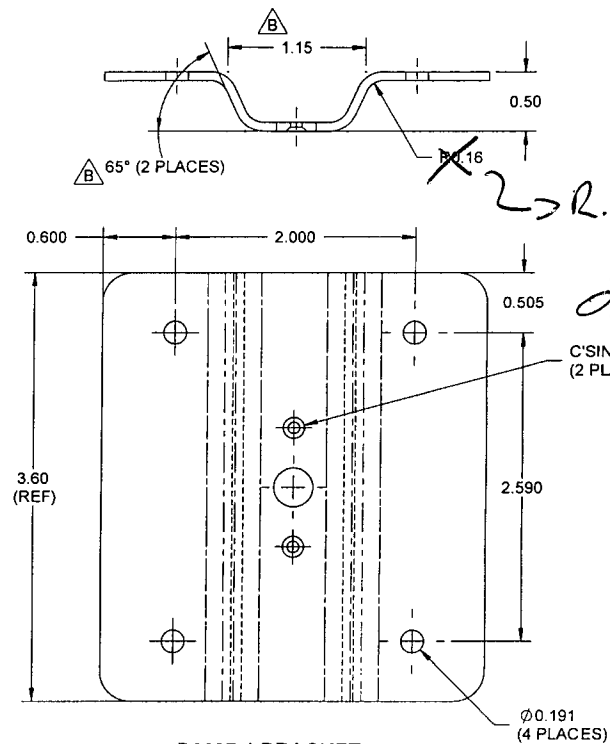


D3637-1F FLAT PATTERN

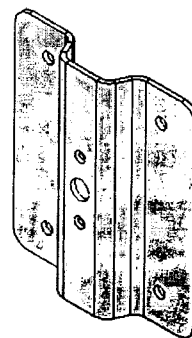
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	CS	D3637	SHEET 2 OF 3
APPROVED	ML	TITLE	SCALE
DE APPR.	ML	BRACKET	1:1
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RELEASED
08.10.27

Date: Tuesday, 7/24/2007 2:44:02 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 33727		
Estimate Number	: 12967		
P.O. Number	:	Part Number	: D36373
This Issue	: 7/24/2007 S.O. No. :	Drawing Number	: D3637 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: AC0005
First Issue	: 1 / Type : SMALL / MED FAB	Drawing Revision	: U/R
Previous Run	:	Material	:
Written By	: <u>JA/07-07-24</u>	Due Date	: 7/31/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-07-20 JLM	Verified By:	

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1407 sf(s)/Unit Total : 0.2814 sf(s)

2024-T3 .050 sheet

Batch: M103321IB 07-07-30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3637

Dwg Rev: PROTOProg Rev: TYPEIB 07-07-30

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

IB 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Form as per Dwg D3637

IB 07-08-03

IB 07-08-03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 33727

Part Number: D36373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**

U 07-08-08



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Dorvalis

Job Completion



FOR ENGINEERING USE ONLY

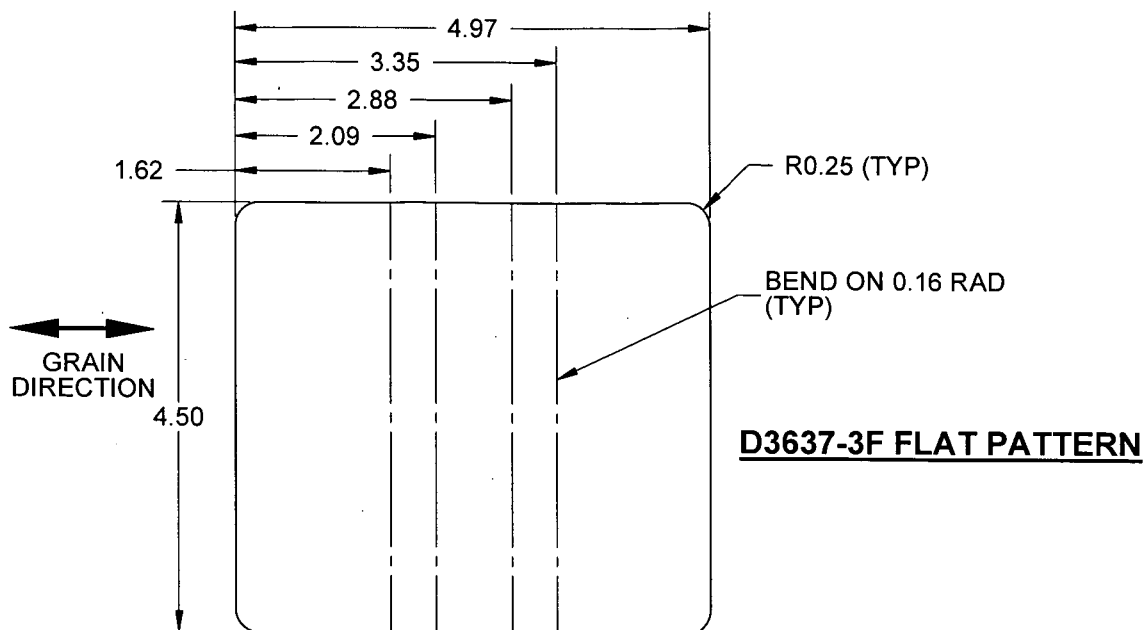
U 07-08-15
w/o 00104.

PROTOTYPE

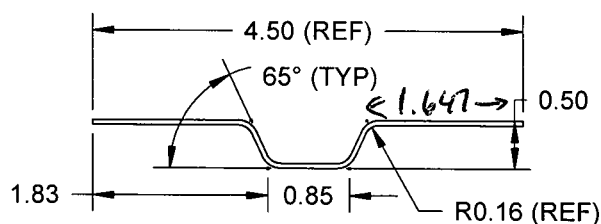
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

LE 07.07.24

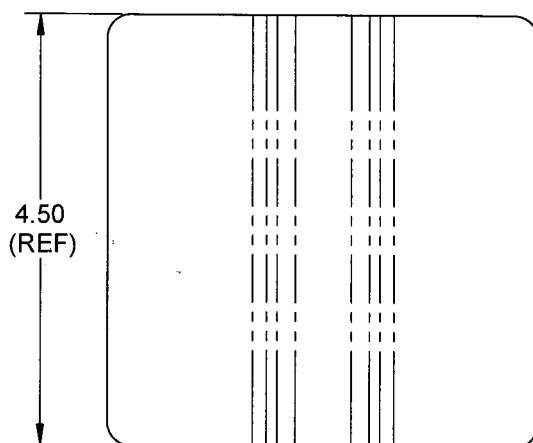
DESIGN TS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED qp	APPROVED	DRAWING NO. D3637	REV. A SHEET 3 OF 3
DATE 07.07.24	TITLE BRACKET		SCALE 2:3



D3637-3F FLAT PATTERN

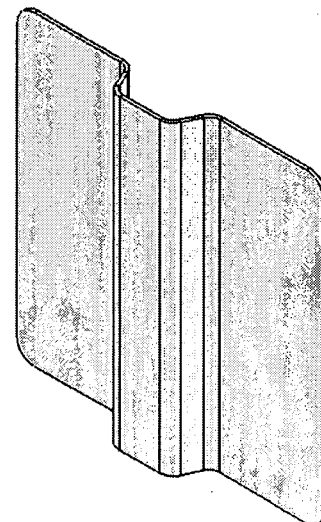


**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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Date: Thursday, 25/10/2007 11:44:55 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: G106091
Job Number	: 35389		
Estimate Number	: 10804		
P.O. Number	: <i>NA</i>	Part Number	: D36373
This Issue	: 25/10/2007 S.O. No. : <i>NA</i>	Drawing Number	: RE-IDENTIFY
Prsht Rev.	: NC	Project Number	: <i>NA</i>
First Issue	: 25/10/2007 Type : SMALL /MED FAB	Drawing Revision	: <i>NA</i>
Previous Run	: 35384	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 01/11/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	78 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

G10609-1 M105654

25
 SCRAP THE 25 PARTS MARKED "SCRAP"
 PER LEANNE

25 scrap C 20711102

52 good

(55)

Used for template

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

DRILL 4 NUTPLATE HOLES AND COUNTERSINK

PER DRWG D3637 REV.A

ml 07/11/19
C 20711102
52 good
(50)

3.0

G106091

Backer plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 78.0000 Each(s)
 Doubler

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.11.19
ENGINEERING
APPROVAL

07/11/20

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RE-IDENTIFY AS D3637-3

USING NEW B/N

57261

07/11/20
(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/11/20
 QA: N/C Closed: _____ Date: _____

NCR: 35389		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/19	2	Made C'sink to deep on 2 parts. (when I starting the job)	<i>[Signature]</i> 05/11/19	Scrap 2 parts and no replace	<i>[Signature]</i> 07/11/19	<i>[Signature]</i> 07/11/19	<i>[Signature]</i> 05/11/19	<i>[Signature]</i> 07/11/19
		P.C - Human error						
		<i>[Signature]</i>						

NOTE: Date & initial all entries

Date: Thursday, 25/10/2007 11:44:55 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: G106091

Job Number: 35389

Part Number: D36373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

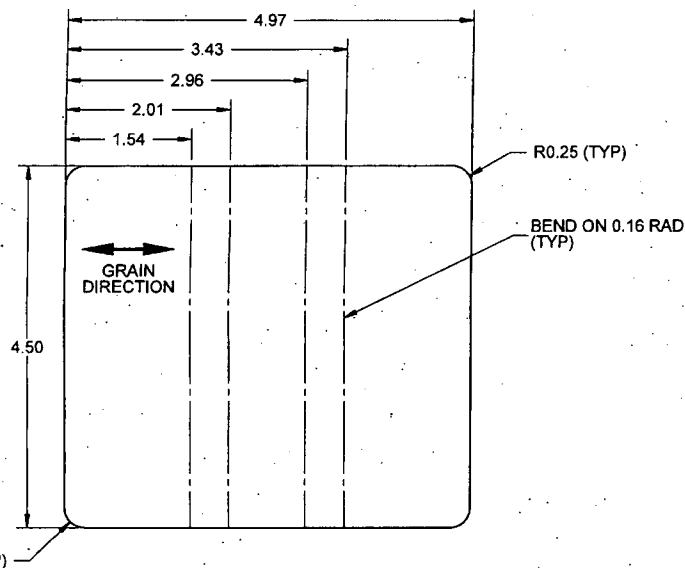
Comment: FINAL INSPECTION/W/O RELEASE

207/11/00

Job Completion

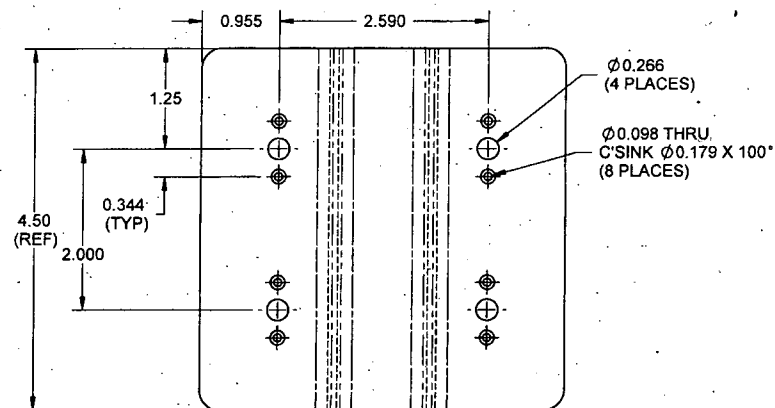
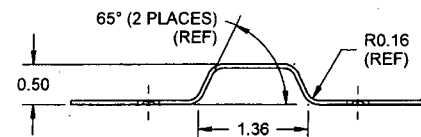


6 Oct. 20

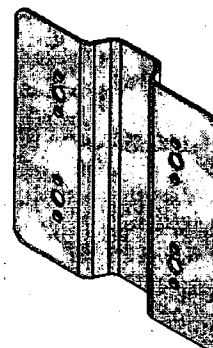


D3637-3F FLAT PATTERN

MS 20426AD3-3



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**

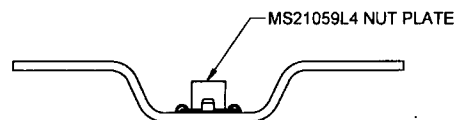


D3637-3 NOTES:

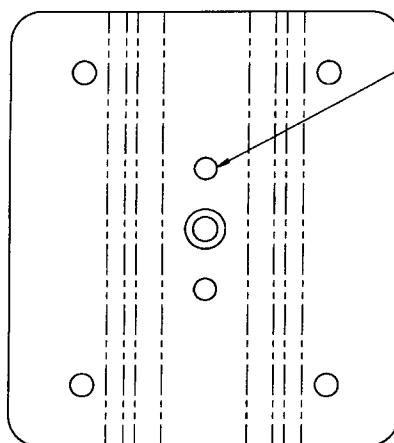
- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EF	DRAWING NO.	REV. A
MFG. APPR.	EF	D3637	SHEET 3 OF 3
APPROVED	EF	TITLE	SCALE
DE APPR.	EF	BRACKET	2:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
07.09.07

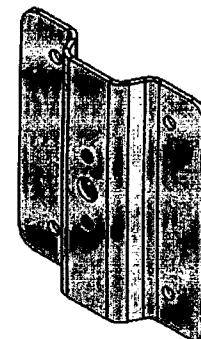


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



W/O 35389

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

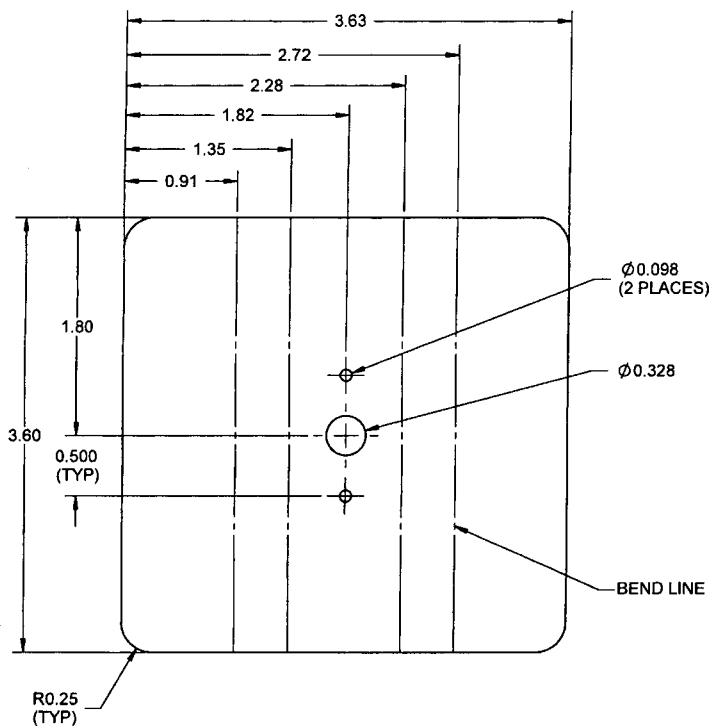
QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

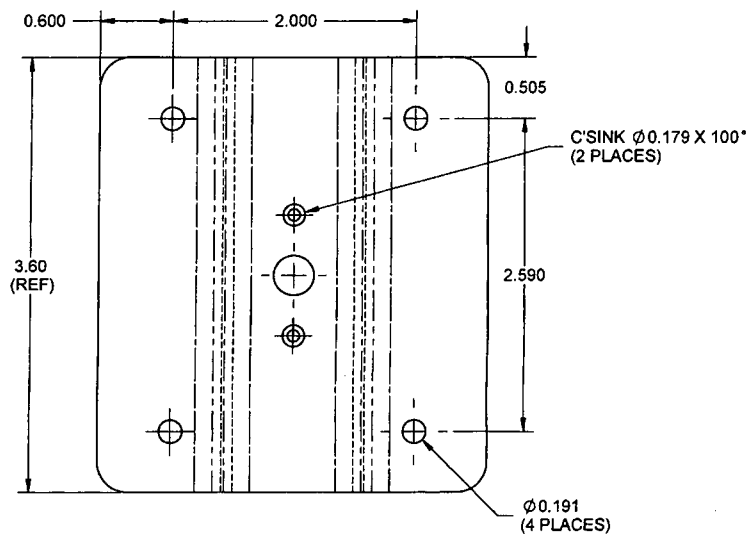
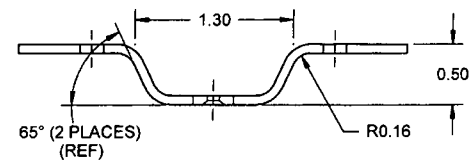
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

RELEASED
07.07.27

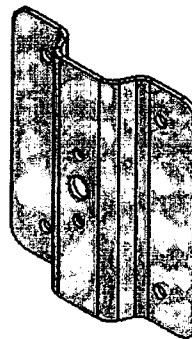
A	NEW ISSUE; REPLACES G10608, G10602 & G10609		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	LF			
CHECKED	BE	DRAWING NO.	REV. A	
MFG. APPR.	BE	D3637	SHEET 1 OF 3	
APPROVED	BE	TITLE	SCALE	
DE APPR.	SH	BRACKET	1:	
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D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



RELEASED
07.09.07

D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GF	DRAWING NO.	REV. A
MFG. APPR.	BF	D3637	SHEET 2 OF 3
APPROVED	BF	TITLE	SCALE
DE APPR.	BF	BRACKET	1:1
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Wb 35389

